

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015516**Date Inspected:** 11-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG LIFT # 9EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 037932, 066179 and 067765 performing Shielded Metal Arc Welding process for weld 003 located on PCMK OBE9C. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld 006 located on PCMK OBE9. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR1701.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068493 performing Flux Cored Arc

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Welding process for weld 004 located on PCMK SP348-001. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068923 performing Flux Cored Arc Welding process for weld 005 located on PCMK SP375-001. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068864 performing Flux Cored Arc Welding process for weld 050 located on PCMK SP347-001. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037907 performing Flux Cored Arc Welding process for weld 053 located on PCMK SP320-001. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS- B-T-2233-B-U2-F.

This Quality Assurance (QA) Inspector observed ABF personnel performing Ultrasonic Inspection for side panel splice weld between OBG segment 9BE and 9CE (cross beam side).

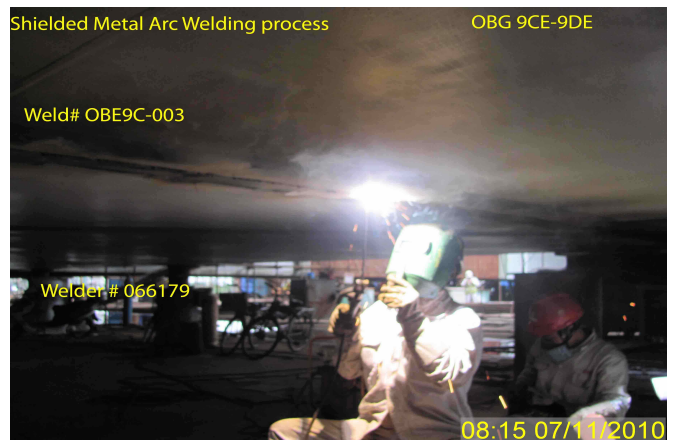
This Quality Assurance (QA) Inspector observed ZPMC personnel performing Ultrasonic Inspection for the weld between cross beam side longitudinal diaphragm web to floor beam at PP76 east side.

OBG SEGMENT 9AW-9BW

This Quality Assurance (QA) Inspector observed ABF personnel performing Magnetic Particle Inspection for the hold back weld between side panels and "T" stiffener in OBG segment 9BW at splice weld between OBG segment 9BW and 9AW (counter weight side).

This Quality Assurance (QA) Inspector observed ABF personnel performing Ultrasonic Inspection for side panel splice weld between OBG segment 9AW and 9BW (counter weight side).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant
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Quality Assurance Inspector

Reviewed By:	Peterson,Art
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QA Reviewer
